

Work Order ID 65094

Thursday, January 06, 2011 10:41:27 AM



Page 1

| | | | | | | |
|----------------|-----------------|------------|------|-------|-------|--|
| Item ID: | D2530 | Accept | | Setup | Start | |
| Revision ID: | | | | | | |
| Item Name: | Handle Weldment | | | | Stop | |
| Start Date: | 1/6/2011 | Start Qty: | 8.00 | | | |
| Required Date: | 1/13/2011 | Req'd Qty: | 8.00 | | | |
| Reference: | | | | | | |
| | | | | | | |

| | | | | | | | | |
|------------|---------------|--|-------|--------|------------|--|-------|--|
| Approvals: | Process Plan: | | Date: | 1/6/11 | Tooling: | | Date: | |
| | QC: | | Date: | | SPC (Y/N): | | Date: | |

| | | |
|-----|-------|--|
| Run | Start | |
| | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|----------|--------------|--|--|--|--|--|--|--|--|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2530 | Rev B | | | | | | | | |

| | | | | | | | | | |
|-----------|----------------------------------|------|--|--|--|--|--|--|--|
| 100 | | 0.00 | | | | | | | |
| | Small Fab | | | | | | | | |
| Small Fab | | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| | 1-Cut to length as per Dwg D2536 | | | | | | | | |
| | 2-Debur | | | | | | | | |

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 110 | | 0.00 | | | | | | | |
| | QC5- Inspect part completeness to step on W/O | | | | | | | | |
| QC | | | | | | | | | |
| Quality Control | Memo | 0.00 | | | | | | | |

| | | | | | | | | | |
|-----------|--|------|--|--|--|--|--|--|--|
| 120 | | 0.00 | | | | | | | |
| | Weld per dwg A/R S.S. rod Batch: 111585 | | | | | | | | |
| Large Fab | Small Fab | | | | | | | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| | 1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301 | | | | | | | | |

8X

=> m-d 11/01/10

8.11.10

XS

lpl 11.01.14

XS

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 65094

Thursday, January 06, 2011 10:41:27 AM



Page 2

Item ID: D2530

Accept



Setup Start



Revision ID:

Item Name: Handle Weldment

Stop



Start Date: 1/6/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|----------------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 QC Quality Control | QC9- Inspect visual per QSI004- Fusion Welds Memo | 0.00 0.00 | BE 11-01-14 | | | 8 | 8 | | |
| 140 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | S.10114 | | | 18 | | | |
| 150 Powdercoat Powder Coating | Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M 112588 Memo START TIME: 7:15 OVEN TEMPERATURE: 320° FINISH TIME: 7:45 | 0.00 0.00 | | | | 8 | 162 | 11-01-19 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 65094

Thursday, January 06, 2011 10:41:27 AM



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Item ID: D2530

Accept



Setup Start



Revision ID:

Item Name: Handle Weldment

Stop



Start Date: 1/6/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|--|----------------------|---------|--------------|--------------|---------------|---------------|------------------|--------------------------------|
| 160 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | ⇒ M 11/01/19 | | 8 | 0 | | |
| 170 Packaging Packaging | Identify as per dwg & Stock Location: <u>506</u> Memo | 0.00 0.00 | | | | | | | |
| 180 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | 11-01-20 MR 11-01-20 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, January 06, 2011 10:41:31 AM

Page 1

Work Order ID: 65094

Parent Item: D2530

Parent Item Name: Handle Weldment

Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304TR0.750W.049

Purchased

No

100

f

217.0212

2.9145

24.54316



304 RD Tube .750 x .049W



m-1 11/01/10

Location

Loc Qty

Loc Code

MAT

202.401171

108498

0

110113

0

114482

6.6065

115010

15.074255

116108 ✓

180.720416

24.54316

MAT014

0.00003

115990

0.00003

MAT017

14.62

109314

9.33

110113

5.29

D2534

Manufactured

No

120

Each

34.0000

2

16



Lock Plate



16 11-01-14

Location

Loc Qty

Loc Code

WA020

34

64929

34

116

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

DART

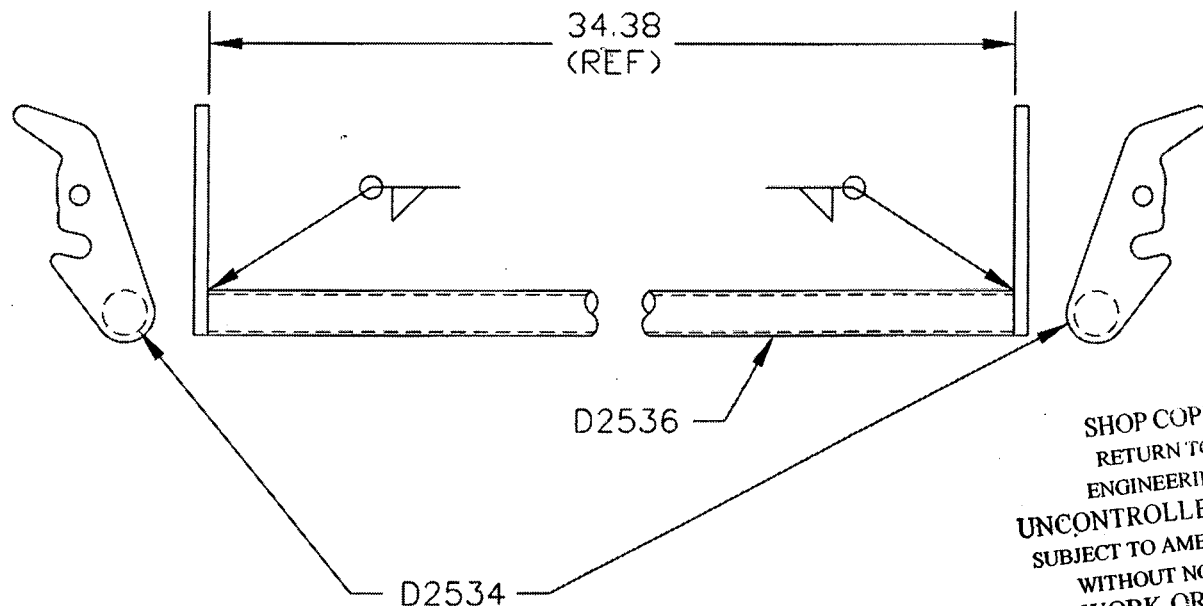
| | | | |
|----------------------------|-----------------------------|--|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| B WILLIAMS | PH | DRAWING NO. | REV. B |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | D2530 | SHEET 1 OF 1 |
| DATE | | TITLE | SCALE |
| 04.12.14 | | HANDLE WELDMENT | |
| A | 96.06.18 | NEW ISSUE | |
| B | 04.12.14 | UPDATE NOTES AND DIMENSIONS | |

RELEASED

04.12.16 *[Signature]*

PART LIST -- D2530

| QTY | PART NUMBER | DESCRIPTION |
|-----|-------------|-----------------|
| X | D2530 | HANDLE WELDMENT |
| | | |
| 1 | D2536 | HANDLE |
| 2 | D2534 | LOCK PLATE |



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45094
B/11-01-6

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

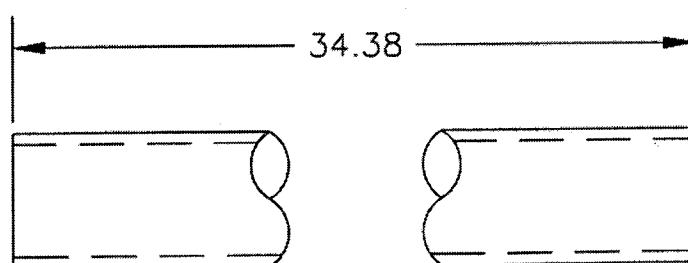


| | | | |
|--------------------|--------------------|--|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD | |
| B WILLIAMS | PH | VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. B |
| <i>[Signature]</i> | <i>[Signature]</i> | D2536 | SHEET 1 OF 1 |
| DATE | TITLE | | SCALE |
| 04.12.14 | HANDLE | | NTS |
| A | 96.05.15 | NEW ISSUE | |
| B | 04.12.14 | UPDATE NOTES | |

RELEASED

04.12.16 *[Signature]*

REFERENCE ONLY



D2536 HANDLE

- 1) MATERIAL: AISI 304/316 SS $\phi 0.75$ X 0.049 WALL (REF. DART SPEC. M304TR0.750W.049)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED